

Work Order ID 55574

January 21, 2010 3:31:06 PM



Page 1

Item ID: D3187-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Floor

Start Date: 1/21/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/21/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3187

Rev C

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Pull from stock:

D3187-1 B31835

apply foam D2986-1 b 2986-1

per drwg D3187-1

IT 10-01-21 (X1)

160

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- install D2986-1 rubber spacer using contact cement and trim to fit if necessary as per dwg D3187-1 A/R contact cement Batch: 112983 2- transfer holes from spacepod floor to rubber spacer

IT 10-01-21 (X1)

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

28060601

(X0) f

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location: *Stores* 0.00

Memo

re-identify suing new B.N

0.00

501/21



190



QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00

Memo

0.00

10/01/21

Pl 10-1-21

Picklist Print

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Page 1

Work Order ID: 55574



Parent Item: D3187-1

Parent Item Name: Spacepod Floor

Start Date: 1/21/10

Required Date: 1/21/10

Comments: IPP: C. 05.04.14 'Now a purchased part' KJ/JLM
IPP Rev:D Now On Waterjet 07-04-19 JLM
IPP Rev:E Now Powder Coated 07-05-24 JLM
IPP Rev:F 09-01-20 rev.c as per dwg DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2986-1

Manufactured No

100

Each

0.8500

1.0000



Rubber Spacer



Et 10-01-21

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

0.85

48237

0.85

Each

9.0000

1.0000

D3187-1

Manufactured No



Spacepod Floor



B54847

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

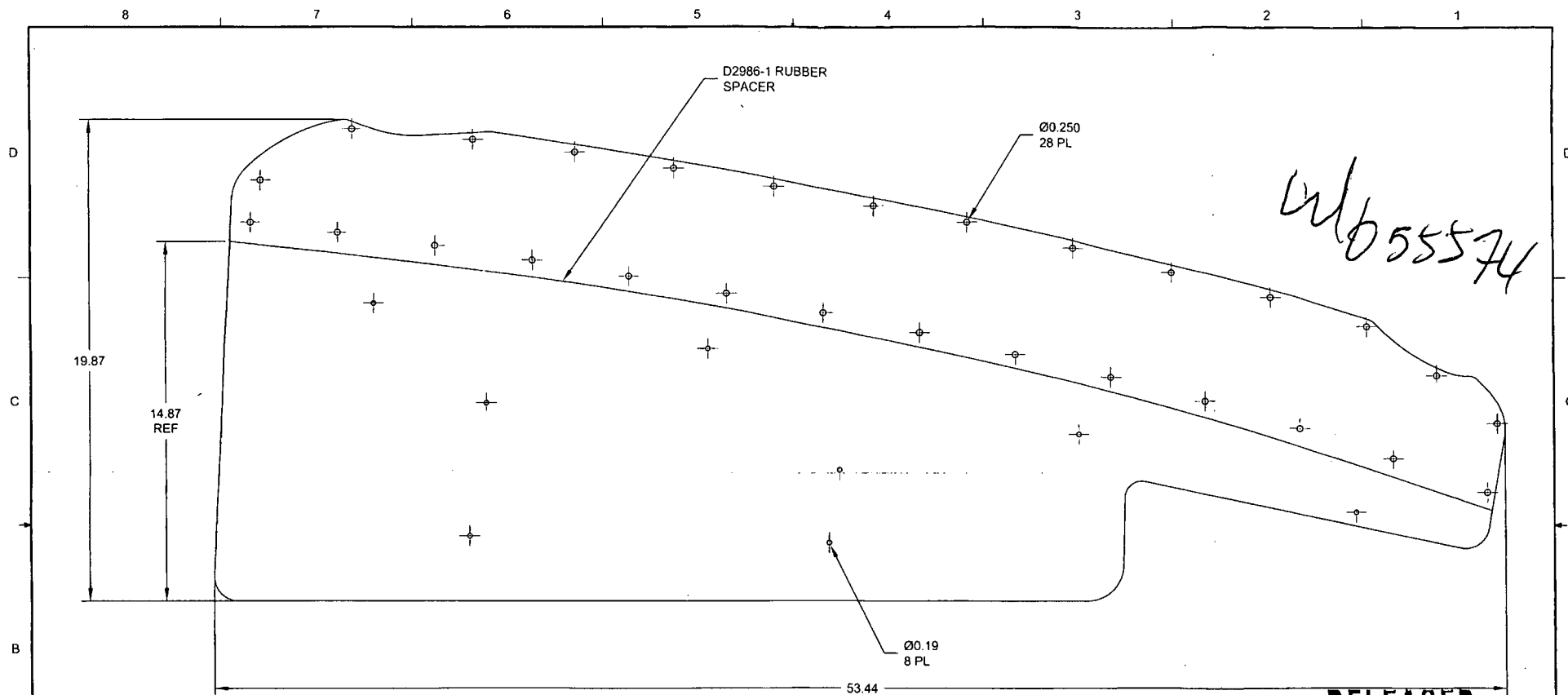
9

31835

9

B31835 (H)

Et 10-01-21



D3187-1 SPACEPOD FLOOR

D3187-1 SPACEPOD FLOOR NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.2 LBS
- 8) TOOLING: CUT/DRILL PER TEMPLATE DT3187-1T1
- 9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

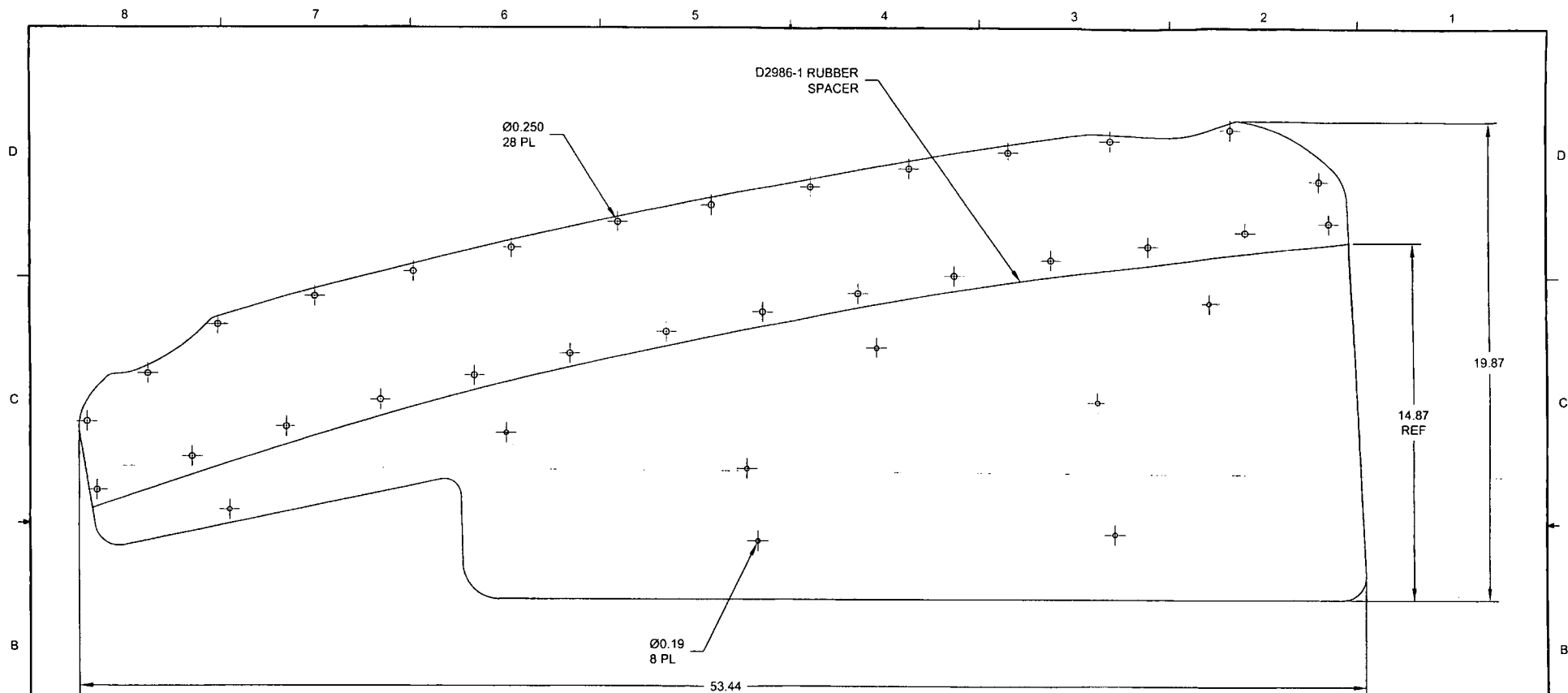
C	REDRAWN TO CURRENT STANDARDS; TRANSFERRED TO B-SIZE FORMAT; ADDED SHEET 2; CREATED DETAIL FOR D3187-2; REVISED SHEET 1 NOTES. REASON: CLARIFIED DRAWINGS FOR D3187-1/-2.	MB	09.01.05
B	CHANGE SHAPE	CP	03.05.16
A	NEW ISSUE	CP	03.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3187
REV. C
SHEET 1 OF 2

TITLE SPACEPOD FLOOR
SCALE NTS

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D3187-2 SPACEPOD FLOOR

D3187-2 SPACEPOD FLOOR NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-2" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.2 LBS
- 8) TOOLING: CUT/DRILL PER TEMPLATE DT3187-1T1
- 9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

RELEASED
09.01.05

55574

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3187 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		SPACEPOD FLOOR NTS
DATE	09.01.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD

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